

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023343**Date Inspected:** 07-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG Trial Assembly				

Summary of Items Observed:

: On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) Trial Assembly Areas

4AE and 4BE (South Side)

This Quality Assurance (QA) Inspector witnessed final tension verification for T-Ribs total 19 nos. and only 18 been inspected for Segment 4AE to 4BE from PP 25 to PP 26 Side Panel Lap Plates checked the gap by sliding 1mm thk. Steel ruler and found ruler is not sliding in. Inspected on 10% random basis found satisfactory and green tag not signed off as no ABF QC was available and held for calibration certificate. Bolt sizes used are M22x2.5x65 RC Set# DHGM220016 and final Torque required is 495 N-m. Manual Torque wrench is been used with Sr. No. X02-584 with calibration due date as 2009.06.26. The Inspection was scheduled at 1540 Hrs. The 1 No. T-Ribs next to Corner Assembly not inspected as shim plate is short in length which has been installed and which is short in length and ZPMC wants to install the appropriate size shim plate there.

4AE and 4BE (North Side)

This Quality Assurance (QA) Inspector witnessed final tension verification for T-Ribs total 19 Nos. Segment 4AE

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to 4BE from PP 25 to PP 26 Side Panel Lap Plates checked the gap by sliding 1mm thk. Steel ruler and found ruler is not sliding in. Inspected on 10% random basis found satisfactory and green tag not signed off as no ABF QC was available and held for calibration certificate. Bolt sizes used are M22x2.5x70 RC Set# DHGM220004 and final Torque required is 453 N-m. Manual Torque wrench is been used with Sr. No. X02-584 with calibration due date as 2009.06.26. The Inspection was scheduled at 1540 Hrs.

4BW

This Quality Assurance (QA) Inspector noticed Traveller Rail Angles installation in progress at PP 26.

4AW and 4BW

This Quality Assurance (QA) Inspector noticed final tension verification for U-Ribs is in progress between PP 25 and 26.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
